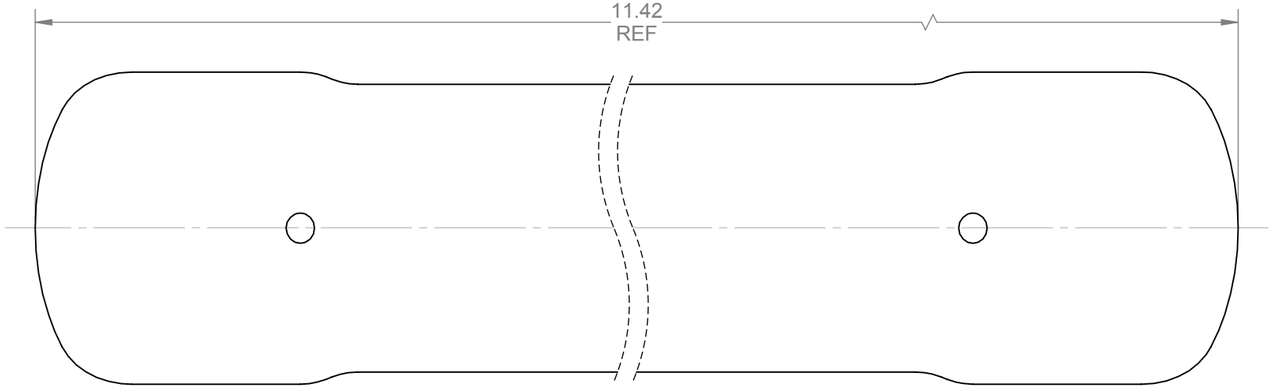
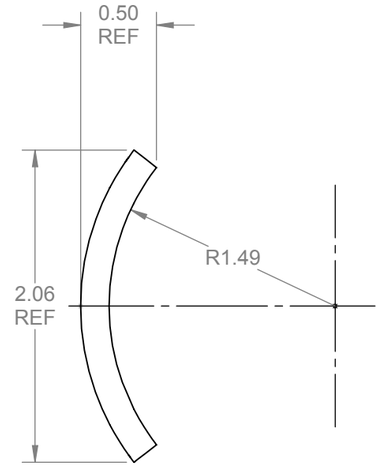
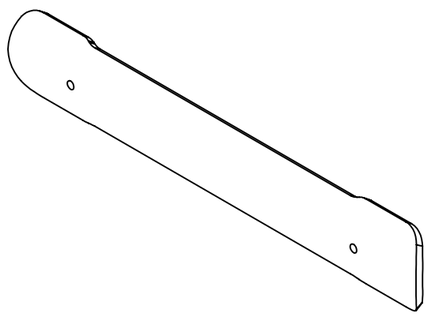
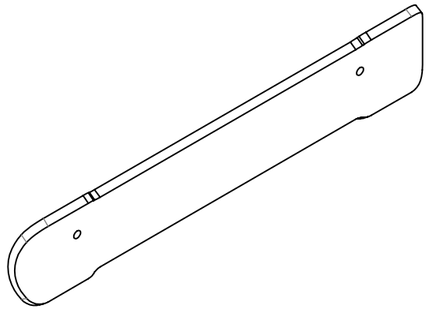




D5520-1 DOUBLER
(BEND DETAIL)





NOTES:
1) MATERIAL: MAKE FROM D5520-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.40 lbs

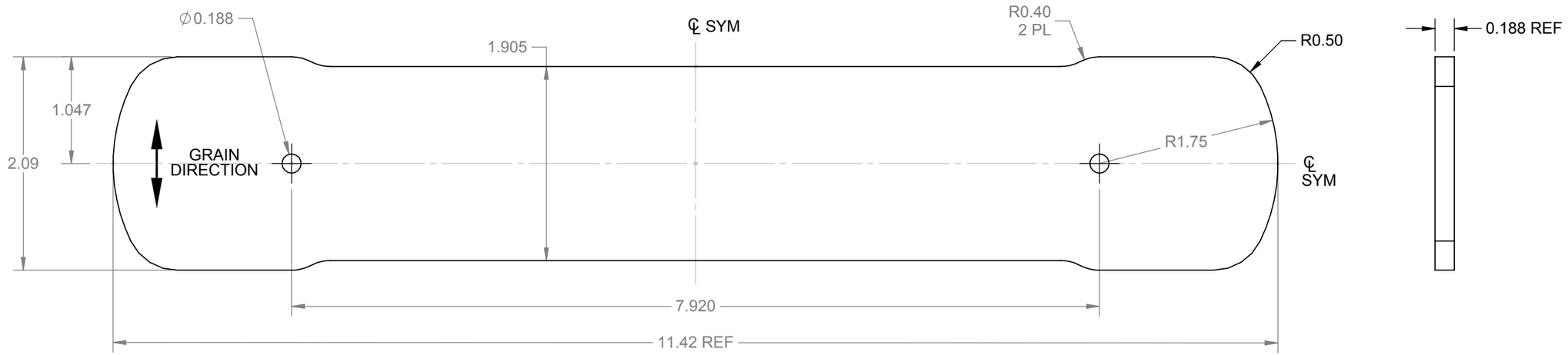
APPROVED BY DESIGN MANAGER

PRELIMINARY ISSUE

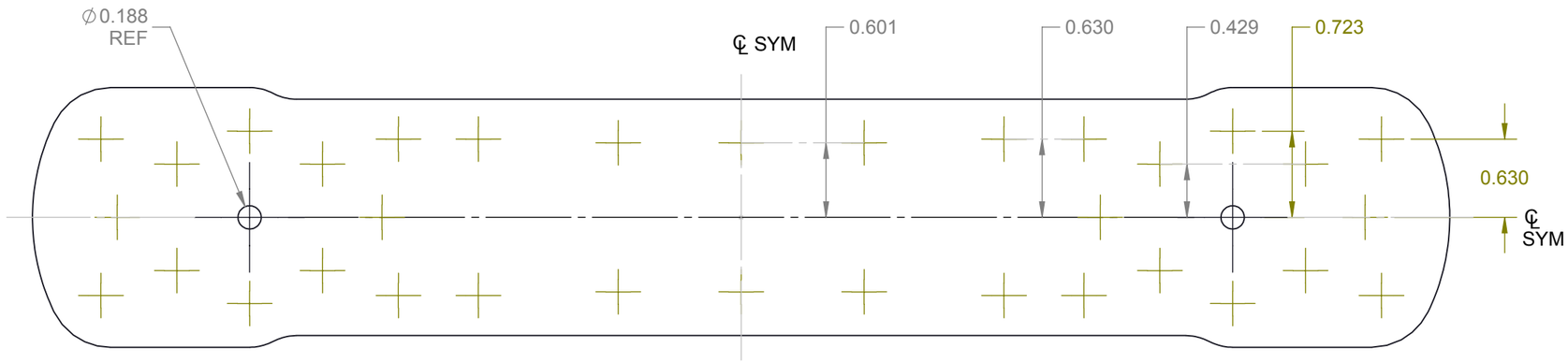
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE (NCR17-6303)	AJS	17.03.09

DESIGN	ML	**DART AEROSPACE USA, INC** EUGENE, OR	
DRAWN	NO		
CHECKED	AJS	DRAWING NO. D5520	REV. A
MFG. APPR.	DD		SHEET 1 OF 2
APPROVED	WM	TITLE DOUBLER	SCALE NTS
DE APPR.			
DATE	17.03.09		

COPYRIGHT © 2017 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



D5520-1F DOUBLER
(FLAT PATTERN)



8 **D5520-1F DOUBLER**
THIS VIEW FOR REFERENCE ONLY
+ INDICATES LOCATION OF RIVET HOLES
TO BE DRILLED ON INSTALLATION
(FLAT PATTERN)

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR/SHEET, 0.188 THICK
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221 OR QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6B0.188 OR M6061T6S0.188
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.40 lbs
8) DOUBLER MUST BE SECURED TO THE SKIDTUBE USING 34 CR3212-5 RIVETS.
RIVETS MUST BE POSITIONED PER THIS VIEW ONCE INSTALLED.
MIN EDGE DISTANCE: 0.322
REF. DT10309

APPROVED BY DESIGN MANAGER

PRELIMINARY ISSUE

DESIGN	ML	**DART AEROSPACE USA, INC.** EUGENE, OR	
DRAWN	NO		
CHECKED	AJS	DRAWING NO. D5520	REV. A
MFG. APPR.	DD		SHEET 2 OF 2
APPROVED	WM	TITLE DOUBLER	SCALE NTS
DE APPR.			
DATE	17.03.09		

COPYRIGHT © 2017 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.